
Date: Monday, 08/09/2008 3:17:11 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SQUARE TUBE

Job Number: 41909

Part Number: PB6743001239

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001225

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Bushing

batch: B40272 ✓

PL 08.10.09

7.0

PB6743001223

Square Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Square Cap

batch: B40042 ✓

PL 08.10.09

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per dwg

PL 08.10.09

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush

2- deburr

PL 08.10.09

(x4)

10.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/10/09

(x4)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/09

(x4)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 512

JS 08/10/10

(x4)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MF 08-10-10

Date: Monday, 08/09/2008 3:17:11 PM
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Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SQUARE TUBE
Job Number	: 41909		
Estimate Number	: 13421		
P.O. Number	:	Part Number	: PB6743001239
This Issue	: 08/09/2008 S.O. No. :	Drawing Number	: B6743001 P.6/P.21
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B1
Previous Run	: 40555	Material	:
Written By	:	Due Date	: 15/09/2008 Qty: <u>4</u> Um: Each
Checked & Approved By	: <u>mf 08-09-08</u>		
Comment	: Est Rev:A 08-06-26 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6TS1000W120

6061T6 SQ TUBE 1.00 x 1.00 X .120w



Comment: Qty.: 1.8375 f(s)/Unit Total: 11.0250 f(s)

6061T6 SQ TUBE 1.00X.120

batch: m109857

SAD 08/09/08

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- cut to length as per dwg

2- make a 0.090" chamfer on both ends of tube

3- deburr

SAD 08/09/10

⑥

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 08/09/11

⑥

4.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- drill holes as per dwg

2- make a 0.090" chamfer (100 degree) on both side of the 4 holes

3- deburr

mw 08/09/13

⑥

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 08/09/22

⑥